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- 65/109.1
1. A turbulator with offset louvers for a heat exchanger comprising:
- 5 a plurality of corrugated fins each having a base extending laterally and longitudinally in a strip; and
- a plurality of offset louvers spaced along said base and extending longitudinally and generally perpendicular to said base in an alternating manner, said
- 10 offset louvers being rolled in a direction parallel to a longitudinal axis of said strip.
- Sub B1
2. A turbulator as set forth in claim 1 wherein said offset louvers extend longitudinally a predetermined
- 15 distance.
3. A turbulator as set forth in claim 1 wherein said offset louvers are spaced laterally a predetermined distance along said base.
- 20 4. A turbulator as set forth in claim 1 wherein said louvers extend generally perpendicular to said base a predetermined distance.

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1. The first and most important step in the process of creating a successful business plan is to conduct a thorough market research. This involves identifying the target market, understanding the needs and preferences of the customers, and analyzing the competitive landscape.

8. A heat exchanger as set forth in claim 7 wherein said turbulator is disposed in said channel.

5 9. A heat exchanger as set forth in claim 6 wherein said turbulator comprises a plurality of corrugated fins each having a generally planar base extending longitudinally and said louvers spaced laterally and extending longitudinally along said base.

10 10. A heat exchanger as set forth in claim 9 wherein said louvers extend generally perpendicular to said base a predetermined distance.

15 11/727 11. A method of making a turbulator with offset louvers for a heat exchanger comprising the steps of:

providing a generally planar strip having a base extending laterally and longitudinally;

forming a plurality of corrugated fins each
20 having having a plurality of offset louvers spaced along the base and extending generally perpendicular to the base in an alternating manner such that the offset louvers extend in a direction parallel to a longitudinal axis of the strip.

forming comprises roll forming.

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forming a plurality of turbulators each having a plurality of corrugated fins with a plurality of louvers spaced laterally and extending generally perpendicular in

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an alternating manner such that the louvers extend in a direction parallel to a longitudinal axis of the strip; disposing the turbulator in the tube; and brazing the tube and the turbulator together.

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17. A method as set forth in claim 16 wherein said step of forming comprises roll forming.

18. A method as set forth in claim 17 including the step of providing a pair of rollers and feeding the strip in a direction of rotation of the rollers to form the louvers.

19. A method as set forth in claim 17 wherein said step of forming comprises forming a planar portion laterally between the louvers.

20. A method as set forth in claim 17 wherein said step of forming comprises forming the louvers with a generally inverted "U" cross-sectional shape.